

Work Order ID 84644

84644

Page 1

May-17-12 11:53:42 AM

Item ID: D3986-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle

Start Date: 17/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/22

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(11)			
D3986	A								

100 FLOW WATER JET 0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3986

6061.063

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

Grain Direction

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

0.00

Quality Control

1312-5-09

1312-5-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 3

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 84644***84644***

Page 4

Item ID: D3986-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle

Start Date: 17/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/6/5 JH
MF
12-06-05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May-17-12 11:53:46 AM

Page 1

Work Order ID: 84644

84644

Parent Item: D3986-1

D3986-1

Parent Item Name: Angle

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP revA 11.06.21 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063		Purchased	No			100	sf	230.0922	0.23	1.452632	3,		
--------------	--	-----------	----	--	--	-----	----	----------	------	----------	----	--	--

M6061T6S 063

6061-T6 .063 Sheet

1812-5-09

Location

Loc Qty

Loc Code

MAT021

230.0922000

113608

0

116308

6.01556842

117285

67.544

119331

44.2

119802

18.94

120218

19.5

120866

66.9426316

121578

6.95

~~120866~~

119802

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

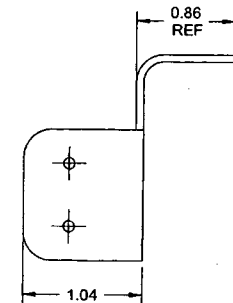
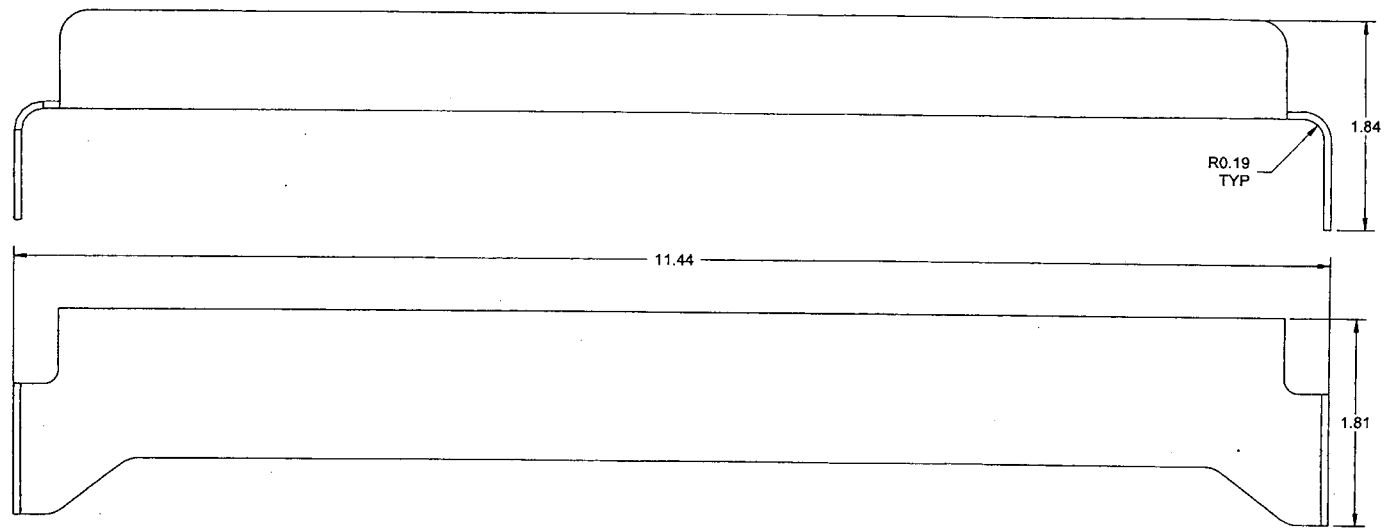
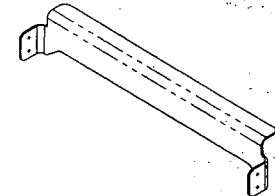
C

B

B

A

A













































SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84644 MW
12/05/22

D3986-1 ANGLE

RELEASED
2011-06-16
MP

NOTES:

- 1) MATERIAL: MADE FROM D3986-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs

A		NEW ISSUE		BY 		11.06.01		
REV.		DESCRIPTION			BY		DATE	
DESIGN		                                         						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____







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NOTE: Date & initial all entries

Technical drawing of a D3986-1F Angle Flat Pattern. The drawing shows a flat pattern for a pipe hanger with dimensions in inches. Key dimensions include a total length of 13.20, a width of 1.27 (2 PL), and a thickness of 0.063 (REF). The pattern features a central bend line, a grain direction arrow, and various radii (R0.25, R0.13, R0.098) and distances (0.79 REF, 1.37 REF, 2.52, 0.55, 0.30 TYP). The pattern is labeled "D3986-1F ANGLE FLAT PATTERN".

RELEASE
2011-06-10

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.15 lbs
8) PART IS SYMMETRIC ABOUT CENTERLINE

DESIGN		DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	D3986	REV. A
MFG. APPR.				SHEET 2 OF 4
APPROVED		TITLE		SCALE
DE APPR.		ANGLE/BRACE		NTS
DATE	11.06.01	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. IT IS NOT TO BE RELEASED TO THE PUBLIC OR TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>		

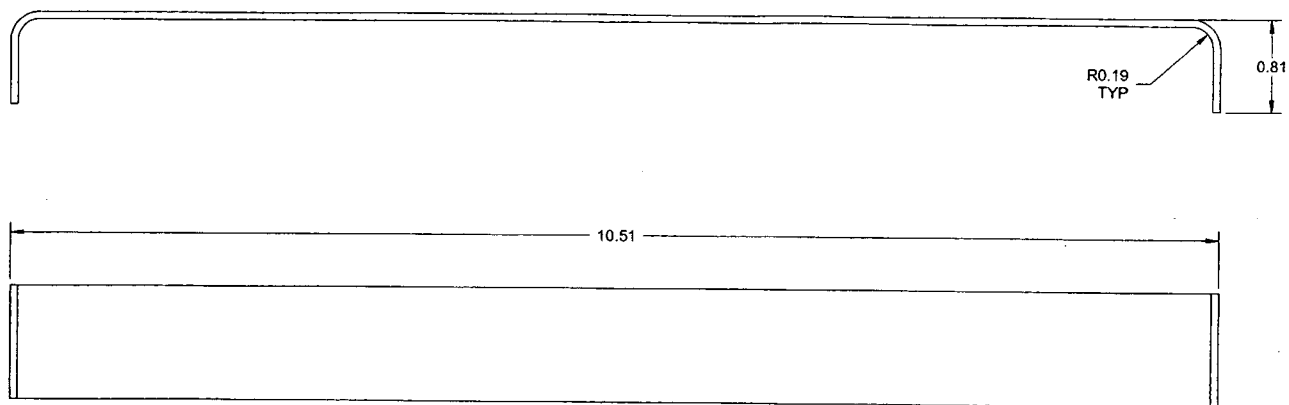
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

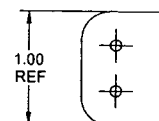
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3986-3 BRACE



RELEASED
2011-06-16
JW

NOTES:

- 1) MATERIAL: MADE FROM D3986-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3986	SHEET 3 OF 4
APPROVED			TITLE	SCALE
DE APPR.			ANGLE/BRACE	NTS
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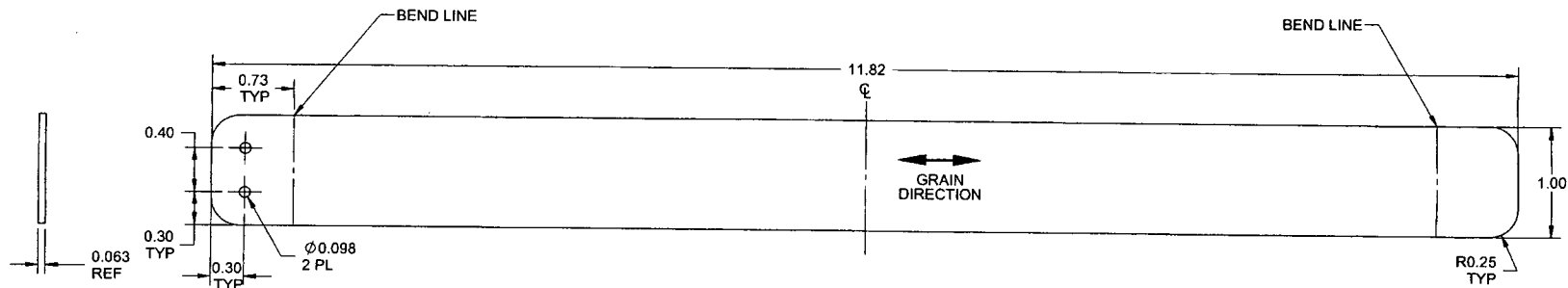
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3986-3F BRACE FLAT PATTERN

RELEASED
2011-06-16

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3986	SHEET 4 OF 4
APPROVED			TITLE	SCALE
DE APPR.			ANGLE/BRACE	NTS
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